Dart Aerospace Ltd. Tuesday, 10/17/2006 11:21:31 AM Kim Johnston User: **Process Sheet** : GAS SPRING ASSEMBLY Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** Job Number : 29047 **Estimate Number** : 10181 : NIA Part Number : D2153 P.O. Number S.O. No. : NIA : D2153 REV. A1 : 10/17/2006 **Drawing Number** This Issue Prsht Rev. Project Number : N/A : NA : PURCHASED/PARTS Type First Issue **Drawing Revision** : 26155 Material **Previous Run** : 10/30/2006 **Due Date** Written By Checked & Approved By : Est: E 02.07.08 Re-format Comment **Additional Product** Job Number: **Machine Or Operation:** Description: Seq. #: 1.0 PG **PURCHASING** Comment: PURCHASING C206/10/17 (108) 2261 Issue P/O:___ Gas Spring P/N: SL13-10 (10lb) attuood. Possible supplier: Spring Lift Corporation **Note: Do not ship by air**** Allow an extra 7 to 10 business days for shipping** Material release note is required D2153P 2.0 Door Prop Comment: Qty.: Total: 1.0000 Each(s)/Unit 12.0000 Each(s) GAS SPRING ASSEMBLY PACKAGING 1 PACKAGING RESOURCE #1 3.0 Comment: PACKAGING RESOURCE #1 Recieive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0

Page 1

QC6

Comment: DIMENSIONAL CHECK

Inspect Test Spring is 10lb

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DATE	STEP	Section A	Initial Chief Eng			Sign & Section (Chief Eng	QC Inspector
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NOTE: Date & initial all entries

Tuesday, 10/17/2006 11:21:31 AM Date: Úser: Kim Johnston **Process Sheet Drawing Name: GAS SPRING ASSEMBLY** Customer: CU-DAR001 Dart Helicopters Services Job Number: 29047 Part Number: D2153 Job Number: Seq. #: Description: Machine Or Operation: Lock Nut 5.0 D30153 24.0000 Each(s) Comment: Qty.: 2.0000 Each(s)/Unit Total: Lock Nut 316 Pick: Qty Part Number Description Ba & 70 6 D3015-3 Lock nut AN960JD516 6.0 7 2.0000 Each(s)/Unit Total: Comment: Qty.: 24.0000 Each(s) 216 Washer Pick: Description Qty Part Number M1.1369 79 AN960JD516 Washer M 1 0 2328 137
Ball Stud 7.0 SL69BS Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s) **Ball Stud** M12458 126 M10036986 Pick: Batch Qty Part Number Description SL69-BS Stud 8.0 SMALL FAB Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Assemble as per Dwg D2153 2- Remove Spring Lift name and address with Acetone, leave only warning: "DO NOT OPEN HIGH PRESSURE" 9.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP PACKAGING 1 10.0 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:

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NOTE: Date & initial all entries

Date:

Tuesday, 10/17/2006 11:21:31 AM

Üser:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING ASSEMBLY

Job Number: 29047

Part Number: D2153

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

QC21

FINAL INSPECTION/W/O RELEASE



108

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

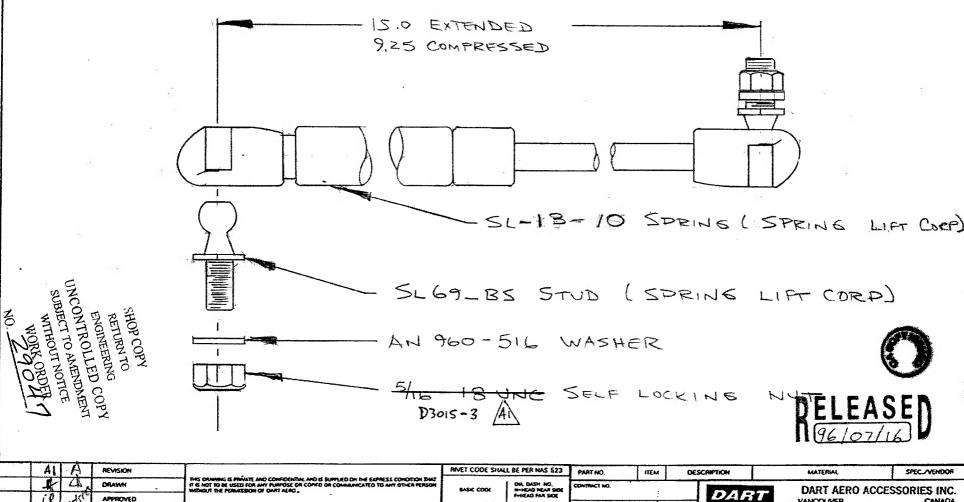


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NOTE: Date & initial all entries



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REQUIREMENTS - UNLESS OTHERWISE SPECIFIED

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04.05.09 SL 13-10 M15L2-10

DESCRIPTION

CHANCE

12153

GAS SPRING ASSEMBLY

DZ153





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